

Work Order ID 126919

126919

Page 1

Monday, December 01, 2014 11:33:27 AM

Item ID: D3822-2KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vertical Tunnel, RH

Start Date: 11/27/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-12-01

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3822-2

Rev. C

100

0.00

DAS

07

9-89

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

14/12/16

105

0.00

DAS

07

9-89

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150 deg. F

DEC 15 2014

Time IN: 5:00 PM

Time OUT: 6:00 AM

Per.....

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Monday, December 01, 2014 11:33:27 AM

Item ID: D3822-2KGY Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Vertical Tunnel, RH
 Start Date: 11/27/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							07 9-89
110		0.00				X/			14/12/16
Thermoform	Memo								
Thermoforming Machine	1-Machine Set-Up								
	2-Pre-heat Tool to required temp.								
	3-Thermoform as per Dwg and Folio #FTA026 using tool DT9074								
	Dwg Rev: C								
	Folio Rev: B								
	Visually inspect for proper formation of each part								
140		0.00							DAS 07 9-89
140		0.00				X/			14/12/18
HandThermo	Memo								
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

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Item ID: D3822-2KGY Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Vertical Tunnel, RH
Start Date: 11/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
150		0.00				Y /			14/12/18
QC	Memo								
Quality Control	Complete FAI document								

160	QC5- Inspect part completeness to step on W/O	0.00
160		0.00
QC	Memo	
Quality Control		

(1)

DAS
38
9-89

DEC 18 2014

170	Identify as per dwg & Stock Location: _____	0.00
170		0.00
Packaging	Memo	
Packaging		

PP 126917

DEC 18 2014

DAS
06
9-89

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Monday, December 01, 2014 11:33:27 AM

Item ID: D3822-2KGY Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Vertical Tunnel, RH
Start Date: 11/27/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 12/02/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							

Quality Control

14/12/18
ME
14-12-18

Picklist Print

Monday, December 01, 2014 11:33:26 AM

Page 1

Work Order ID: 126919

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Parent Item: D3822-2KGY

D3822-2KGY

Parent Item Name: Vertical Tunnel, RH

Start Date: 11/27/14

Required Date: 12/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC v
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
52068

Purchased

No

100

sf

3,800.000

7.8

8

DAS

07

9-29

MKYD6185S 080-P3-52068

Kydex steel grey (52"x96"-.080)

17/12/18

Location

Loc Qty

Loc Code

LAIRD

1180

m129546

347

m129760

347

m130383

486

therm

2620

119476

61

121902

819

122181

1046

m127759

347

m128321

347

8 sg A4

DART AEROSPACE LTD		Work Order:	126919
Description: Vertical Tunnel, RH		Part Number:	D3822-2KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

DAS

Measured by: 07
9-89

Date: 14/12/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.8	Min	0.97"	✓			
0.3	Min	0.347"	✓			
0.55	Min	0.74"	✓			
0.040	Min	0.061"	✓			
0.050	Min	0.068"	✓			

DAS

Measured by: 07
9-89 DAS

Date: 14/12/18

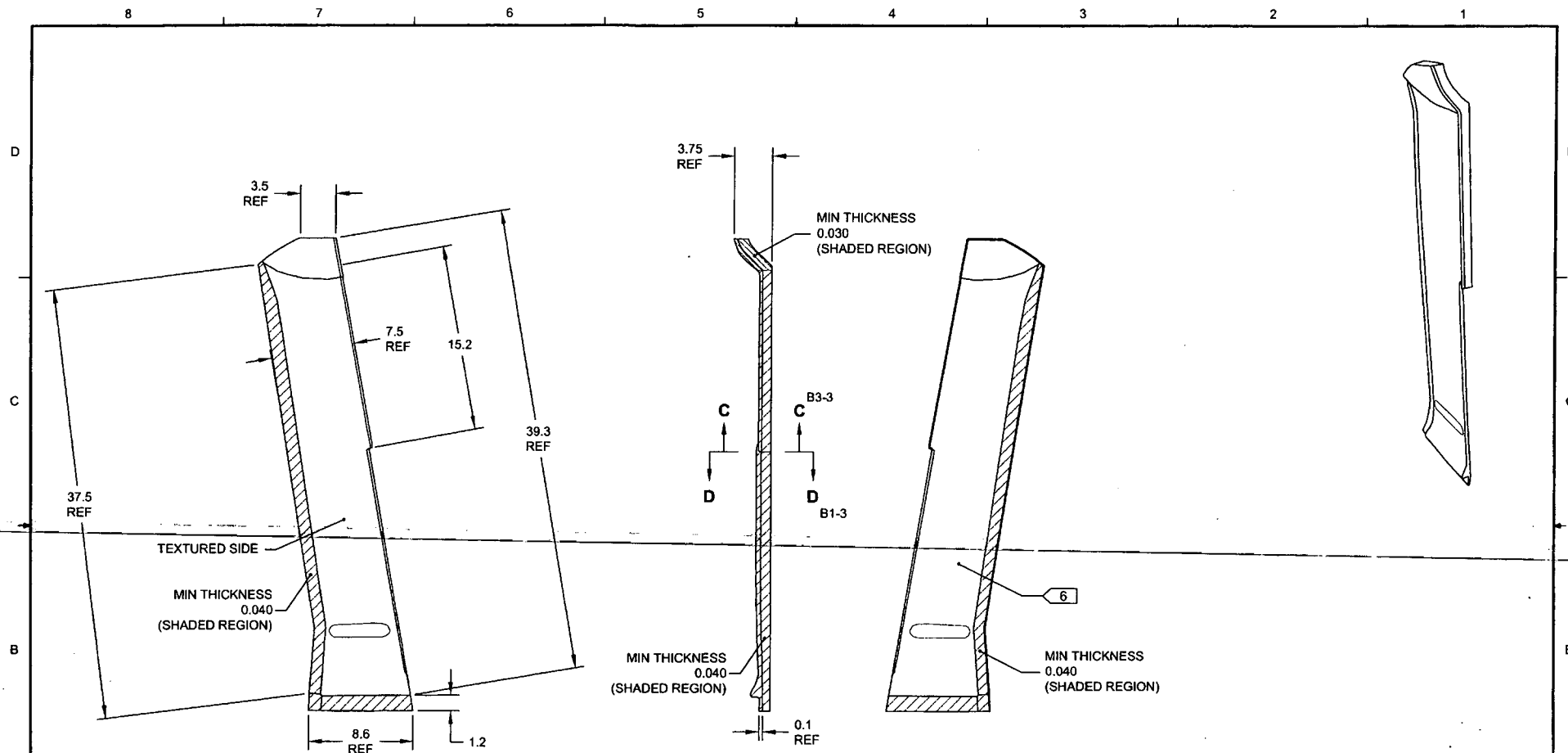
Audited by: 38
9-89

Date: DEC 18 2018

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	



D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	DART AEROSPACE LTD
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. REV. C
MFG. APPR.	PH	D3822 SHEET 2 OF 6
APPROVED	PH	TITLE SCALE
DE APPR.	PH	VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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